ASBP

Work Ord Tuesday, October				*10	8162*							Page 1
Item ID: Revision ID:	D4130-7			Accept	*N90	nn4r	110	N *	Setup	Start	I VI	S1*
Item Name: Start Date: Required Date: Reference:	10/8/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Ite					Stop	*N:	S2*
Approvals:		in: MF.	Date: 13-10			Date:]	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr				*						***
D4130	В											
*100 *100* Waterjet FLOW CNC Waterje	et	FLOW WATER JET Memo 1-Cut as pe Dwg Rev: Prog Rev: 2-Deburr if	3	0.00 0.00				6	(O		Ae 13.10.08
*110 *110* QC Quality Control		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				_6	. —	Ö		Ae 13.10.0
*120 *120*		QC8- Inspect parts - seco	ond check	0.00 الم				Ģ				
QC Quality Control		Memo		0.00 B Q	.9			-1.				

									*		DQA:	Date:	
NCR:	es /	No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date:	ø.
						I	-				QA Closed.	Date.	
Work Orde	. ė.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE						Rework	ר		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap	┪ '		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	···					Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR N	No.					Work Order Update	1	L	Large Fab	Composite	,	Supplier	
						_							
Root				i	Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	D	ate	Step	Qty	(or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data							1						
Equip/Tooling													,
Operator													
Material												-	
Setup				,	,								
Other	Ц				 		İ	:					
Process	Ц												
Supplier	Ш												
Training			٠										
Unapproved													
						 	FAUI	LT CATE	GORY				
Landi	ng Gear				Γ	General		٦			1	· 	1
	Ben	-				Bend	_	Grain			Ovalized		Pressure/Forced
	\vdash		Concer	itric to	o/s	BOM/Route	-	Hardwa			Over/Under		Temperature/Cure
	Crac				<u> </u>	Broken/Damaged	<u> </u>	- 1 `	on Incomplete	<i></i> . ⊢	Part Incorred		Weld
			rimped		 	Burrs	\vdash	-	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuff				L	Contamination	<u> </u>	Mainte		<u></u>	Part Moved		
<u>.</u>	⊢	t Treat			<u> </u>	Countersink	<u> </u>	Mislabe		<u> </u>	Positioned V	_	1
	Insp	ection	Strip in	Tube		Cut Too Short	ı	Misread	l		Power Loss/	Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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Work Ord Tuesday, Octob				*108	3162*						Page
Item ID: Revision ID:	D4130-7			Accept	*N900	040	100)* ·	Setup Sta	1 71	S1*
Item Name: Start Date: Required Date: Reference:	10/8/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item 1 Customer:	ID:			Sto	^р *N	S2*
Approvals:	Process Pla	ın:	Date:	Tooling: SPC (Y/N):		ate:			Run Sta Sto	1/1	R1* R2*
Sequence ID/ Work Center II 130 *120* Packaging Packaging)	Operation Description Identify as per dwg & Sto		Set Up/ Run Hours 0.00 66 3 \rightarrow 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13-10-10 13-10-09

Page 2

									DQA:	Date:	
NCR: Yes	/ No			WC	ORK ORDER NON-C	ONFORM	MANCE / UP	DATE	QA Closed:	Date:	¥
Work Order:				,	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Description of	of work order update	Initial	Ad	tion	Sign &	·	
Cause	Date	Step	Qty	or Non	-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator											
Material Setup Other											
Process Supplier Training											\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.
Tranning	I	I	1			1	1		l		

FAULT CATEGORY

General

	-,		_	-	•		7 .
L	Bending	Bend		Grain	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Ŀ	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect		Weld
Г	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved		•
Γ	Heat Treat	Countersink		Mislabeled	Positioned Wrong		_
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge		Other
	Ripples in Bend	Drill Holes		Offset			
	Torque Waves in Extrusion	Drawing		Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			· · · · · · · · · · · · · · · · · · ·
	Wave/Twist in Tube	Folio		Outside Dimensions			

Unapproved

Landing Gear

Picklist Print

Tuesday, October 08, 2013 9:18:14 AM

Page 1

Work Order ID:

108162

Parent Item:

D4130-7

Parent Item Name:

Center Cargo Floor Protector

Start Date: 10/8/2013

Required Date: 10/11/2013

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 10.06.08 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,471.4520	17.674	-125			
GE PLASTICS LEXAN SI	HEET										_Ae_	<u> 13.11</u>	<u>5. 0 }</u>
				Location		Loc Qty	Lo	c Code					
				MAT018		2471.452	2						

286.792

2184.66

124866

m126425

							•				DQA:	Date	:
NCR: Y	es /	No			,	WORK ORDER NON-C	OI	NFORM	MANCE / UPDATE		04 (14)	Data	
						<u> </u>					QA Closed:	Date	· · · · · · · · · · · · · · · · · · ·
Work Orde	or:					DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS	•
Part N						Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Cross Machining Smal noforming Finis Large Fab Comp	l Fab	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	tion of work order update		I Initial	Action		Sign &		
Cause	<i>'</i>	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator									,				
Material													
Setup													
Other				ļ									
Process	П												
Supplier	П												
Training	П												
Unapproved	П	·											
						F	AUI	LT CATE	GORY				
Landi	ng Ge	ar				General		_			_		_
	∏в₁	ending				Bend		Grain			Ovalized		Pressure/Forced
		entre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	C	racks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct _	Weld
	C	rushed/0	Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Пс	uffs				Contamination		Mainte	nance		Part Moved	_	
	Пн	eat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	_
	Πır	spection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other
	П。	innloc in	Rond			Drill Holes		Officet			_		

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

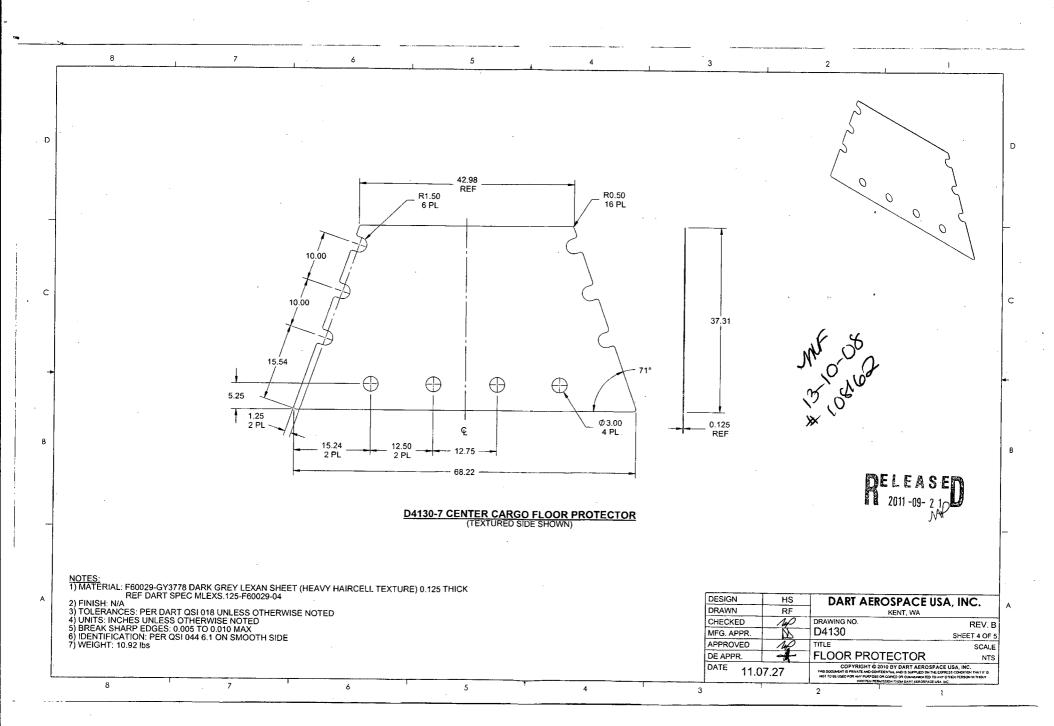
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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											DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-C	ON	NFORM	AANCE / UPI	DATE	OA Classel		.	17
											QA Closed:	Da	te:	
Work Orde	er.					DISPOSITION		-		AGAINST DE	PARTMENT	/PROCESS		
Part N	 No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root	-1			-	Descri	ption of work order update		nitial	Δct	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance		ief Eng		ription	Date	Verificatio	n	QC Inspector
Doc/Data			4.46	Α.,			-						٠.	
Equip/Tooling	Н													
Operator	Н											*		·
Material	П													
Setup	П		·			·		i						
Other														
Process	П												:	
Supplier	П	'	1											
Training							1							
Unapproved														
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Landi	ng G	ear				General				_	_			•
		Bending				Bend		Grain		_	Ovalized		L	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	\vdash	Hardwa			Over/Under		<u> </u>	Temperature/Cure
	Ш	Cracks				Broken/Damaged		1	on Incomplete		Part Incorre		_	Weld
	—	Crushed/0	Crimped			Burrs	\vdash		ions Incomplete/l	Unclear	Part Lost/Mi	ssing	L	Wrong Stock Pulled
,	${f H}$	Cuffs				Contamination	-	Mainte		L	Part Moved			
	Ш	Heat Trea	it			Countersink		Mislabe	led	Ŀ	Positioned V	-	_	· ,
		Inspection	n Strip in	Tube	L	Cut Too Short	\vdash	Misread	İ	L	Power Loss/	Surge	<u> </u>	Other
		Ripples in	Bend		·	Drill Holes		Offset						•

Out of Calibration

Outside Dimensions

Out of Sequence

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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DART AEROSPACE LTD	Work Order: 108162
Description: Center Cargo Floor Protector	Part Number: D4130-7
Inspection Dwg: D4130 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.012/-0.001	3,00			V	JKm - 01
42.98	+/-0.030	42.98	-		T	JKM-06
68.22	+/-0.030	68.22	1		7	JAIR CE
37.31	+/-0.030	37.31			T	
10.00	+/-0.030	10,00	-		7"	
15.54	+/-0.030	15,54			Τ	
5.25	+/-0.030	5.25	_		7	
1.25	+/-0.030	1.25	_		T	
12.50	+/-0.030	12.50	_		T	
12.75	+/-0.030	12.75	_	-	T	
0.125	+/-0.010	130	-		V	
	Ç.					
	-					

		- Part		
Measured by:	Audited by:	27	Preliminary Approval:	
Date: 13.10.08	Date:	13 10-9	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.10.25	New Issue	KJ (\/	pp.oved
В	12.05.15	Dwg Rev updated	KJ 👯	7111
		<u> </u>		(-/2//

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
												QA Closed:	Date:		
Vork Order:							DISPOSITION	1	AGAINST DEPARTMENT/PROCESS						
Part No.							Rework Scrap		, ° – 1		Small Fab	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other	
NCR No.											Finishing Composite	Rec/stor	Supplier	Other	
Root					Descr		iption of work order update		nitial	Action		Sign &			
Cause	ause D		Step	o Qty		or Non-conformance		Ch	ief Eng	Desc	Description		Verification	QC Inspector	
oc/Data quip/Tooling perator laterial							•			·					
etup ther rocess upplier raining napproved		`			·										
FAULT CATEGORY															
Landir	ng Gear						General					_			
	Cer Cra Cru Cut Hea Ins Rip	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset			Over/Under tolerance Ten Part Incorrect Wei Part Lost/Missing Wro Part Moved Positioned Wrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Tor	Torque Waves in Extrusion					Drawing	<u></u>	Out of Calibration					· · · · · · · · · · · · · · · · · · ·	
	Turning Sequence						Finish	1	Out of Sequence						

Outside Dimensions

DQA:

Date:

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Wave/Twist in Tube

Folio